IN THE CLAIMS:

1. (Previously Amended) A method of making reinforced paperboard cartons comprising the steps of:

   (a) advancing a web of paperboard along a path, the web of paperboard having a width;

   (b) progressively applying at least one ribbon of reinforcing material to the advancing web of paperboard to form a reinforced region for the carton, the ribbon having a width less than the width of the web of paperboard and an edge;

   (c) scoring fold lines in the web of paperboard, at least one of the fold lines extending transversely to the reinforcing region and crossing the edge of the ribbon of reinforcing material to define a fold line having a first section within the reinforced region and a second section outside the reinforced region, the first section of the fold line being wider than the second section of the fold line; and

   (d) forming a transition zone between the first and second sections of the fold line.

2. (Original) The method of claim 1 and where in step (e) the transition zone comprises a widening of the fold line from the narrower second section of the fold line to the wider first section of the fold line.

3. (Original) The method of claim 2 and where in step (e) the fold line widens smoothly from the second to the first sections of the fold line.

4. (Original) The method of claim 2 and wherein the edge of the reinforcing ribbon is located within the transition zone nearer the wider portion of the fold line.

5. (Original) The method of claim 1 and wherein step (c) further comprises impressing the paperboard with a multi-point scoring rule having a narrower section outside the reinforced region and a wider section inside the reinforced region.

6. (Original) The method of claim 5 and wherein the scoring rule is part of a platen die cutter.

7. (Original) The method of claim 5 and wherein the scoring rule is part of an in-line rotary die cutter.

8. (Original) The method of claim 5 and wherein step (c) further comprises locating a counter plate beneath the scoring rule, the counter plate being formed with a groove aligned with the scoring rule, the groove having a narrower section aligned with the narrower section of the scoring rule and a wider section aligned with the wider section of the scoring rule.

9. (Original) The method of claim 8 and where in step (e) the transition zone is formed by gradually widening the groove in the counter plate from its narrower section to its wider section.

10. (Original) The method of claim 9 and wherein the junction between the narrower and the wider sections of the scoring rule is aligned with the wider end of the transition zone.

11. (Previously Amended) A method of scoring a fold line in a paperboard carton blank having a base sheet of paperboard and a reinforced region formed by a reinforcing ribbon laminated to the base sheet wherein the fold line extends transversely to the reinforced region and transitions from outside the reinforced region to inside the reinforced region, the method comprising the steps of:

(a) providing a multi-point scoring rule having a narrower first section for scoring the portion of the fold line outside the reinforced region and a wider second section for scoring the portion of the fold line within the reinforced region; and

(b) impressing the paperboard carton blank with the multi-point scoring rule to form the fold line in the paperboard carton blank.

12. (Original) The method of claim 11 and where in step (b) the paperboard carton blank is sandwiched between the multi-point scoring rule and a counter plate, the counter plate formed with a groove aligned with the scoring rule with the groove having a narrower

section aligned with the narrower section of the scoring rule and a wider section aligned with the wider section of the scoring rule.

13. (Original) The method of claim 12 and wherein the groove in the counter plate is further formed with a transition region between its narrower section and its wider section to form a fold line with a corresponding transition region at the edge of the reinforcing ribbon.

14. (Original) The method of claim 13 and wherein the transition region of the groove comprises a gradually widening section of the groove from its narrower section to its wider section.

15. (Original) The method of claim 14 and wherein the transition region of the groove is about .125 inches long.

16-32 (Canceled)

33. (Previously Amended) A method of making reinforced paperboard carton blanks comprising the steps of:

(a) advancing a web of paperboard along a path, the web of paperboard having a width;

(b) advancing at least one ribbon of reinforcing material along a path, said reinforcing material having a width less than the width of said web of paperboard;

(c) progressively deforming the ribbon of reinforcing material;

(d) progressively laminating the deformed ribbon of reinforcing material to the web of paperboard to form a reinforced paperboard carton blank; and

(e) forming fold lines across the web of paperboard and reinforcing material.

34. (Original) The method of claim 33 and wherein step (c) comprises passing the ribbon of reinforcing material between a pair of impression cylinders.

35. (Original) The method of claim 34 and wherein the surfaces of said impression cylinders are configured to form an array of perforations in said ribbon of reinforcing material.

36. (Original) The method of claim 34 and wherein the surfaces of said impression cylinders are configured to form longitudinal flutes in said ribbon of reinforcing material.

37. (Original) The method of claim 34 and wherein the surfaces of said impression cylinders are configured to form transverse corrugations in said ribbon of reinforcing material.

38-41 (Canceled)